

Work Order ID 84613

May-17-12 10:38:51 AM

84613

Page 1

Item ID: D3167-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bearpaw

Start Date: 17/05/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 31/05/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 12/05/17

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--|----------------------|---------|----------|--------------|---------------|---------------|------------------|----------------|
| Draw Nbr | Revision Nbr | | | | | | | | |
| D3167 | Rev A1 | | | | | (4) | | | |
| 120 | | 0.00 | | | | | | | |
| *120* | FLOW WATER JET | | | | | | | | |
| Waterjet | Memo | 0.00 | | | | | | | B12-6-2 |
| FLOW CNC Waterjet | Cut Blank as per File D3167-1_BLANK | | | | | | | | |
| 130 | | 0.00 | | | | | | | |
| *130* | HAAS CNC VERTICAL MACHINING #1 | | | | | | | | |
| HAAS 1 | Memo | 0.00 | | | | | | | |
| HAAS CNC vertical machine #1 | Note: (2) Bearpaw for (1) Kit 1-Inspect material for defects or damage prior to machining 2-Machine as per Folio FA285 and Dwg D3167 3-Deburr | | PO/B.A | 12/07/05 | | 4 | Ø | | B12-6-2 |
| 140 | | 0.00 | | | | | | | |
| *140* | QC2- Inspect parts off machine FAI/FAIB | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | PO/B.A | 12/07/05 | | 4 | Ø | | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Work Order ID 84613

May-17-12 10:38:51 AM

84613

Page 2

Item ID: D3167-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Bearpaw

Stop

NS2

Start Date: 17/05/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 31/05/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC8- Inspect parts - second check

0.00

150

QC

Memo

0.00

Quality Control

151

Identify as per dwg & Stock Location: _____

0.00

151

Packaging

Memo

0.00

Packaging

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.00

Quality Control

OK / 8

12-07-09

(x4)

Perp/s (4)

K 12/7/10

ME 12-07-10

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
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NOTE: Date & initial all entries

Picklist Print

May-17-12 10:38:55 AM

Page 1

Work Order ID: 84613

84613

Parent Item: D3167-1

D3167-1

Parent Item Name: Bearpaw

Start Date: 17/05/2012

Required Date: 31/05/2012

Start Qty: 4.00

Required Qty: 4.00

Comments:

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| MUHMWB10 | | Purchased | No | | | 120 | sf | 53.2100 | 3.6 | 14.4 | | | |

MUHMWB10

UHMW 1" Black

**

1812-6-2

| Location | Loc Qty | Loc Code |
|----------|-------------|----------|
| MAT018 | 30.1 | |
| 120972 | 3 | |
| 121346 | 27.1 | |
| MAT019 | 1.5 | |
| 118814 | 1.5 | |
| ST052 | 21.60999474 | |
| 121277 | 12.8 | |
| 121278 | 8.80999474 | |

121951

121851

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |




Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

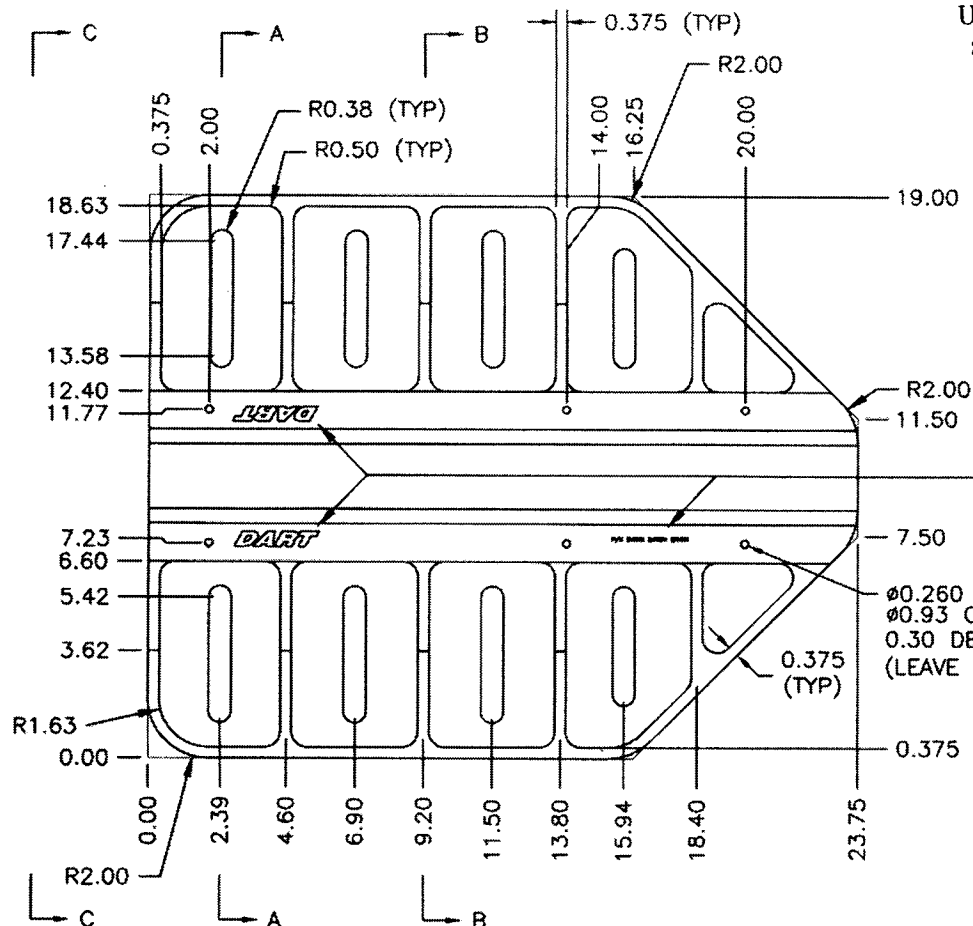
| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

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| CHECKED | APPROVED | DRAWING NO. | | REV. A | |
|  |  | D3167 | | SHEET 1 OF 2 | |
| DATE | | TITLE | | SCALE | |
| 02.10.08 | | BEARPAW | | 1:6 | |
| A | 02.10.08 | NEW ISSUE | | | |
| A1 | 02.12.17 | 5.80 WAS 5.50 | |  | |

ENGRAVE LOGO TO MAX
DEPTH OF 0.012. ENGRAVE
PART AND BATCH NUMBERS
TO MAX DEPTH OF 0.010.
(TYPICAL LOCATION AS
ILLUSTRATED)



D3167-1

MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
1.00 THICK (MACHINE TO 0.950)
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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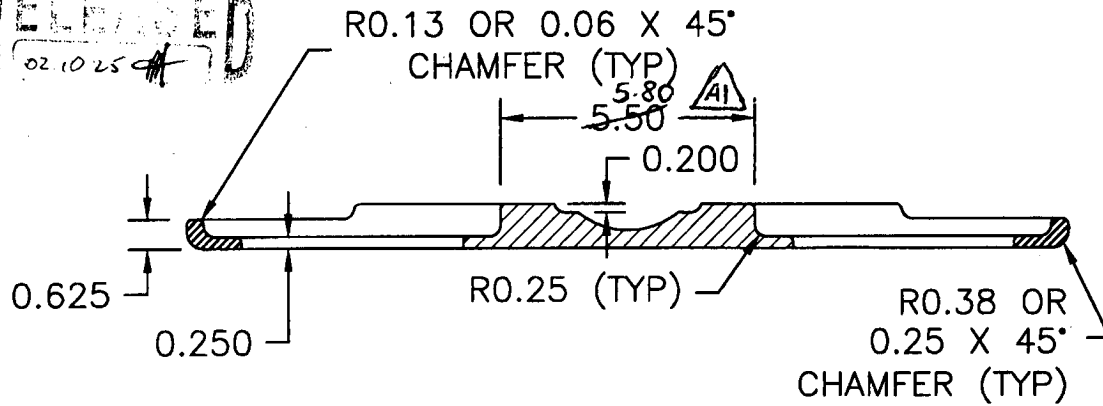
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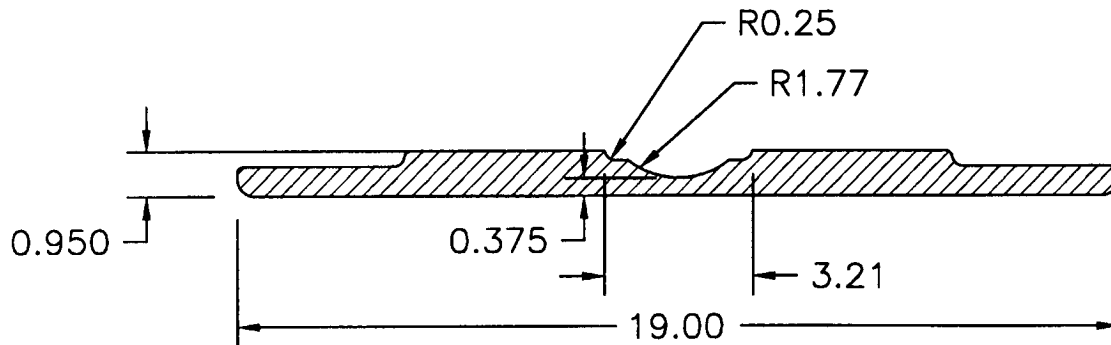


| | | | |
|------------------|--------------|---|------------------------|
| DESIGN | DRAWN BY | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | APPROVED | DRAWING NO. D3167 | REV. A SHEET 2 OF 2 |
| DATE 02.10.08 | | TITLE BEARPAW | SCALE 1:4 |

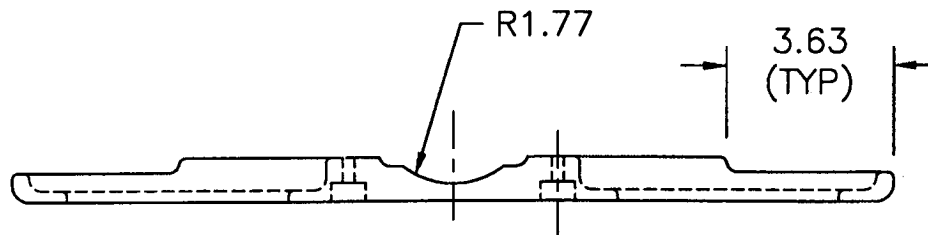
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02.10.25



SECTION A-A



SECTION B-B



SECTION C-C

04613

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| | | | |
|---|--|---------------------|----------------|
| DART AEROSPACE LTD | | Work Order: | |
| Description: Bearpaw | | Part Number: | D3167-1 |
| Inspection Dwg: D3167 Rev: A1 | | Page 1 of 1 | |

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**

 ☐ **Prototype**

| Inspection Sheet Drawing Dimension | | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|---------------------------------------|------------|---------------|---------------------|--------|--------|-------------------------|----------|
| A | 0.06 x 45° | +0.030/-0.010 | 0.063 x 45° | ✓ | | PHD-01 | VERN. |
| B | 5.80 | +/-0.030 | 5.799 | ✓ | | " | " |
| C | 0.25 x 45° | +/-0.030 | 0.250 x 45° | ✓ | | " | " |
| D | R0.25 | +/-0.030 | 0.250 | ✓ | | Rad Gauge | |
| E | 0.200 | +/-0.030 | 0.209 | ✓ | | PHD-09 | |
| F | 0.250 | +/-0.010 | 0.243 | ✓ | | HB-120 | |
| G | 0.625 | +/-0.030 | 0.624 | ✓ | | PHD-01 | VERN. |
| H | 0.375 | +/-0.010 | 0.377 | ✓ | | HB-120 | |
| I | 0.950 | +0.030/-0.010 | 0.949 | ✓ | | PHD-01 | VERN. |
| J | 3.21 | +/-0.030 | 3.210 | ✓ | | " | " |
| K | 19.00 | +/-0.030 | 19.00 | ✓ | | PHD-11 | M. TAPE |
| L | Ø0.260 | +0.005/-0.000 | 0.260 | ✓ | | PIN gauge | |
| M | Ø0.93 | +/-0.030 | 0.931 | ✓ | | PHD-01 | VERN. |
| N | 0.30 | +0.030/-0.000 | 0.319 | ✓ | | PHD-09 | |
| O | 0.375 | +/-0.030 | 0.379 | ✓ | | PHD-01 | VERN. |
| P | 7.23 | +/-0.030 | 7.230 | ✓ | | H. gauge | |
| Q | 4.54 | +/-0.010 | 4.553450 | ✓ | | PHD-01 | VERN. |
| R | 2.00 | +/-0.030 | 2.017 | ✓ | | PHD-01 | " |
| S | 12.000 | +/-0.010 | 12.001 | ✓ | | H gauge | |
| T | 6.000 | +/-0.010 | 6.000 | ✓ | | PHD-01 | VERN. |
| U | 23.75 | +/-0.030 | 23.750 | ✓ | | PHD-11 | M. TAPE |
| | | | | | | | |
| | | | | | | | |
| | | | | | | | |
| | | | | | | | |

| | | | |
|--------------------------|---------------------------|----------------------------|-----|
| Measured by: PD/B | Audited by: AT/ang | Prototype Approval: | N/A |
| Date: 12/07/05 | Date: 12/07/09 | Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|---------------------------------|------------|----------|
| A | 03.09.22 | New Issue P/O D130-700-011 | KJ/RF | # |